

Work Order ID 153264

Tuesday, November 15, 2016 11:17:47 AM

153264

PRELIMINARY ISSUE

Page 1

Item ID: 647.7352

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skid Deflector Assembly

Start Date: 12/22/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/22/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: VS

DAS
21
9-89

Date: 10/11/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7352								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

SHIP DEC 23TH

POSITIVE
RECALL

DAS
6
9-89

DEC 16 2016

DAS
27
9-89

DAS
21
9-89

16-12-16

DEC 20 2016

DEC 16 2016

DAS
6
9-89

DEC 16 2016

16-12-21

DAS
27
9-89

DEC 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 153264

Tuesday, November 15, 2016 11:17:47 AM

153264

Page 2

Item ID: 647.7352

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skid Deflector Assembly

Start Date: 12/22/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/22/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP 647.7352
Location : FG109

DEC 20 2016

140

0.00

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

DEC 21 2016

DAS
21
9-89DAS
21
9-89

DEC 21 2016

POSITIVE RECALL

EFFECTIVE 12/11/17 AUTH

RELEASED DATE

R016-1006-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, November 15, 2016 11:17:47 AM

Page 1
1

Work Order ID: 153264

153264

Parent Item: 647.7352

647 7352

Parent Item Name: Skid Deflector Assembly

Start Date: 12/22/2016

Required Date: 12/22/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.09.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1702 *647 1702* Skid Deflector Assembly LN9025-0820K		Manufactured	No				Each	0.0000		2 <u>133319</u>	DAS 6 9-89	DEC 16 2016	MF
✓ *I N9025-0820K* Lock Tab Washer LN9037-08018		Purchased	No				Each	0.0000		8 <u>136260</u>	DAS 6 9-89	DEC 16 2016	MF
I N9037-08018 Screw		Purchased	No				Each	0.0000		8 <u>136189</u>	DAS 6 9-89	DEC 16 2016	MF

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 16: T1/P1 Skid Deflector (SD) Assembly, 647.7351

FIND #	PART #	DESCRIPTION	QTY
3	647.1701	SKID DEFLECTOR ASSY	2
33	647.2510	SLEEVE	4
34	647.2511	NUT	4
51	601.3002	BOLT	4
54	601.3209	LOCKNUT	4
95	601.1097	WASHER	8

Table 17: T2/P2/T3/P3 SD Assembly, 647.7352

FIND #	PART #	DESCRIPTION	QTY
105	647.1702	SKID DEFLECTOR ASSY	2
106	601.3655	LOCK WASHER	8
107	601.3654	BOLT	8

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 153264

DEC 16 2016



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 16: T1/P1 Skid Deflector (SD) Assembly, 647.7351

FIND #	PART #	DESCRIPTION	QTY
3	647.1701	SKID DEFLECTOR ASSY	2
33	647.2510	SLEEVE	4
34	647.2511	NUT	4
51	601.3002	BOLT	4
54	601.3209	LOCKNUT	4
95	601.1097	WASHER	8

Table 17: T2/P2/T3/P3 SD Assembly, 647.7352

FIND #	PART #	DESCRIPTION	QTY
105	647.1702	SKID DEFLECTOR ASSY	2
106	601.3655	LOCK WASHER <i>Ln9035-0820k</i>	8
107	601.3654	BOLT <i>Ln9037-08018</i>	8

Work Order ID 153264

Friday, December 16, 2016 10:20:28 AM

153264

Page 1

Item ID: 647.7352

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EC135 T2/P2/T3/P3 Skid Deflector Assembly

Start Date: 12/22/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/22/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

MPP-195

REV N/C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP 647.7352

DAS
21
9-89

DEC 16 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
Engineering Clerk
Document Administrator

DART AEROSPACE
T 1 613 632-5200 > ext. 226
F 1 613 632-9311



From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lmcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

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M +1-613-676-0577
F +1-613-632-5146
+1-800-556-4166
www.dartaerospace.com

From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM